

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009305**Date Inspected:** 26-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1745**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Ying Xin.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay10, East Tower, Struts.

SMAW welding of weld joint ED1-A6001-2-7B, 9A; located on Bay10, East Tower. Welders are identified as 053049, 052493; ZPMC Quality Control Inspector (QC) is identified as Chen Ying Xin. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-3212-TC-U5B-1.

Bay10, South Tower, Struts Repair.

Repair gouge out noticed on strut weld Identified as SD1-A6002-9-9A. see attached picture for details.

This QA Inspector carried out NDE on following:

Bay10, South Tower, Lift 3, AE Corner Seam(89M to 99M Double Diaphragm).

This QA inspector performs Random Ultrasonic Testing (UT) of approximately 10% area previously tested and accepted by ZPMC Quality Control personnel, FOR GREEN TAG. This QA Inspector generated an UT report (TL-6027) for this date. The members are identified as SSTL3-1B/K-84A.

Outside Yard(Heavy Dock), East Tower, Lift 1, Skin C, Bearing Plate.

This QA inspector performs Random Visual Testing (VT), Magnetic Particle Testing (MT) of area previously

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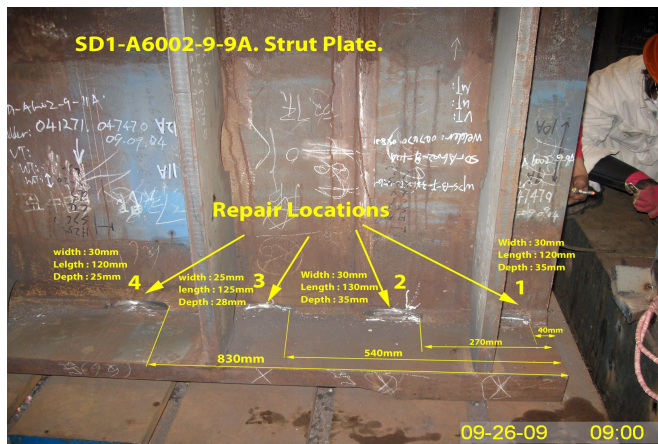
tested and accepted by ZPMC Quality Control personnel, FOR GREEN TAG. This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as ESD1-SA294F/G-89, 92.

Outside Yard(Heavy Dock), East Tower, Lift 1, Skin C, NCR # ZPMC0388 Closing(After repair).

This QA inspector performs Random Visual Testing (VT), Magnetic Particle Testing (MT) of area previously tested and accepted by ZPMC Quality Control personnel, FOR GREEN TAG. This QA Inspector generated an MT report (TL-6028) for this date. For members identification refer NCR # ZPMC0388.

During this Inspection QA inspector found Slag Pocket at the Inspection Area(Length 5mm, width 2mm) Item No # 2(Linear Indication 5mm long) on the NCR # ZPMC0388, ZPMC agreed to remove slag & repair the spot. NCR # ZPMC0388 not closed. No Incident report submitted on this issue.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
